

Work Order ID 53196

October 26, 2009 11:50:19 AM



Page 1

Item ID: D2606

Accept



Setup Start



Revision ID: A1

Stop



Item Name: Console Bracket, 206/407 Console

Start Date: 05/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 29/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: PL

Date: 09-10-26

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2606

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2606
Deburr if necessary

☐ Dwg Rev: A1

☐ Prog Rev: A1

☐ 2-

B 9-10-28

(30)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-10-28

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) 50910/28

counters
(X30)

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Item ID:	D2606	Accept		Setup	Start	
Revision ID:	A1				Stop	
Item Name:	Console Bracket, 206/407 Console					
Start Date:	26/10/2009	Start Qty:	20.00		Cust Item ID:	
Required Date:	29/10/2009	Req'd Qty:	20.00		Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00				30	✓		
Brake NC	Deburr Form as per Dwg D2606								
				09/14/03					
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				count	✓		
Quality Control						30			
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
				09/11/04					
						X30	✓		

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Item ID: D2606
Revision ID: A1
Item Name: Console Bracket, 205/407 Console

Accept



Setup Start



Stop



Start Date: 26/10/2009 Start Qty: 20.00
Required Date: 29/10/2009 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

AND 09/11/05

130

09/11/05 (30)

09/11/06

MF 09-11-05

Picklist Print

October 26, 2009 11:50:23 AM

Page 1

Work Order ID: 53196



Parent Item: D2606RevA1



Parent Item Name: Console Bracket, 206/407 Console

Start Date: 26/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	192.7334	3.1726	5.000		
2024-T3 .040 sheet												

IB 9-10-28


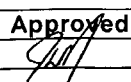
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	192.7333789	
110337	6.4	
111786	37.0665789	111786
112291	66.4027	112291
112331	82.8641	

DART AEROSPACE LTD		Work Order:	53194
Description: Console Bracket		Part Number:	D2606
Inspection Dwg: D2606 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

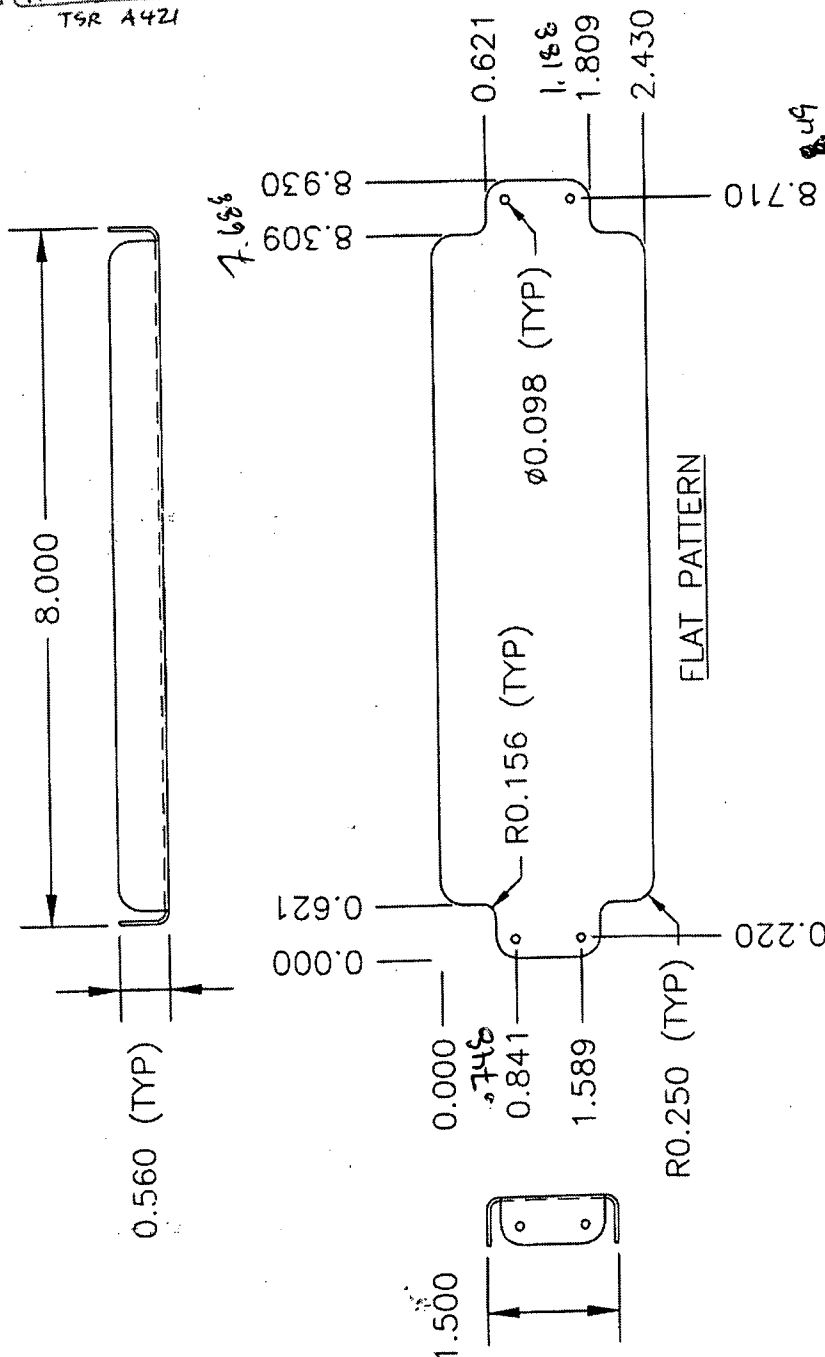
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.841	+/-0.005	0.843	X			
1.589	+/-0.005	1.589	X			
0.621	+/-0.010	0.624	X			
1.809	+/-0.010	1.810	X			
2.430	+/-0.010	2.432	X			
0.621	+/-0.010	0.626	X			
8.309	+/-0.010	8.312	X			
8.930	+/-0.010	8.930	X			
8.710	+/-0.010	8.710	X			
R0.250	+/-0.010	0.250	X			
R0.156	+/-0.010	0.156	X			
Ø0.098	+0.005/-0.000	0.101	X			
0.040	+/-0.005	0.040	X			

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	9-10-20	Date:	09/10/20	Date:	N/A
Rev	Date	Change	Revised by	Approved	
A	05.02.17	New Issue	KJ/JLM	 	



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
LE	BW	D2606	SHEET 1 OF 1
DATE	TITLE	SCALE	
97.10.23	CONSOLE BRACKET	1:2	
A	97.10.23	D2606 WAS D206-547-27	
AI	02.06.04	ADD FINISH	

RELEASED
97.11.04 KE
TSR A421



SHOP COPY
RETURNED
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 53196
09-10-26

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2606
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART Q51.005 4.1 (AI)